Date: Monday, 11/6/2006 2:01:24 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206L/L/L3/L4 HIGH GEAR SKID
Job Number	: 29325		
Estimate Number	: 10526		
P.O. Number	: N/A	**Part Number**	: D206642412
This Issue	: 11/6/2006 **S.O. No.** : N/A	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: N/A
Previous Run	: 29324	**Material**	: N/A
Written By	:	**Due Date**	: 11/30/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: KJ 06 11 07		
Comment	: Est Rev:K 06.10.11 Revised picklist per CHG004 KJ/CP/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D206-642-412 CHG004 KJ 06.11.09 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	29325A	206 L HIGH GEAR SKIDTUBE

Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE
D206-642-441 B 29325A

Seq. #:	Machine Or Operation:	Description :
3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
4.0	D2652	Bushing

Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
24	D2652	Bushing	B28933 ✓
1	D206-642-441(REF)		B29325B ✓

Seq. #:	Machine Or Operation:	Description :
5.0	D2655	Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2655	Tow Ring	B28856 ✓

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:01:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 29325 **Part Number:** D206642412

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2659	Lug Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2659 Lug Assembly B29228 ✓

Seq. #:	Machine Or Operation:	Description :
7.0	D2712	Set Screw

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
10 D2712 Set Screw B26481 ✓

Seq. #:	Machine Or Operation:	Description :
8.0	D29322	206 Saddle Right side

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D2932-2 Saddle B29231 ✓

Seq. #:	Machine Or Operation:	Description :
9.0	D29332	206 Saddle Right

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D2933-2 Saddle B30487 ✓

Seq. #:	Machine Or Operation:	Description :
10.0	D2934	Saddle Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2934 Saddle Spacer B29345

Seq. #:	Machine Or Operation:	Description :
11.0	D2935	Saddle Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2935 Saddle Spacer B29346

 Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 29325

Part Number: D206642412

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D29382	206 Saddle Right side

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2938-2	Saddle	B28863 ✓

Seq. #:	Machine Or Operation:	Description :
13.0	D29392	206 Saddle Right Side

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2939-2	Saddle	B28864 ✓

Seq. #:	Machine Or Operation:	Description :
14.0	D2968043	Tow Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2968-043	Tow Ring	B28865 ✓

Seq. #:	Machine Or Operation:	Description :
15.0	AN337A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN3-37A	Bolt	M17478 ✓

Seq. #:	Machine Or Operation:	Description :
16.0	AN341A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN3-41A	Bolt	M101938 ✓

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 29325 **Part Number:** D206642412

Job Number:

Seq. #:	Machine Or Operation:	Description :
17.0	AN45A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 AN4-5A Bolt M100657 ✓

18.0	AN46A	Bolt

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
12 AN4-6A Bolt M102959 ✓

19.0	AN511A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN5-11A Bolt M101291 ✓

20.0	AN512A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN5-12A Bolt M102380 ✓

21.0	AN513A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN5-13A Bolt M15928 ✓

22.0	AN960JD10	Washer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
12 AN960JD10 Washer M100274 ✓

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 29325
Part Number: D206642412

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

23.0 AN960JD1016 Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part Number	Description	Batch
1	AN960JD1016	Washer	M5519

24.0 AN960JD416 Washer

Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty	Part Number	Description	Batch
25	AN960JD416	Washer	M101938

25.0 AN960JD516 Washer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty	Part Number	Description	Batch
8	AN960JD516	Washer	M102929

26.0 AN9704 Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part Number	Description	Batch
1	AN970-4	Washer	M102929

27.0 MS21042L3 Nut

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Qty	Part Number	Description	Batch
12	MS21042L3	Nut (or -3)	M102277

28.0 MS21042L4 Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty	Part Number	Description	Batch
13	MS21042L4	Nut (or -4)	M19185

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes $\boxed{\text{No}}$ **DQA:** [signature] **Date:** 07/02/22

QA: N/C Closed: ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:01:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 29325 **Part Number:** D206642412

Job Number:

Seq. #:	Machine Or Operation:	Description :
29.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

C 07/02/20

Seq. #:	Machine Or Operation:	Description :
30.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-642-412
Location:__________
PPP Rev: C

07/02/20
07/2/20

Seq. #:	Machine Or Operation:	Description :
31.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/02/22

Job Completion

07-02-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CP12

Dart Aerospace Ltd.

Date: Monday, 11/6/2006 2:02:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 29325A		
Estimate Number	: 10522		
P.O. Number	: N/A	**Part Number**	: D206642441
This Issue	: 11/6/2006 **S.O. No.** : N/A	**Drawing Number**	: D2650 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: E
Previous Run	: 29324A	**Material**	: N/A
Written By	:	**Due Date**	: 11/30/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06 11 07		
Comment	: Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D206-642-441 CHG002 N/A

2.0	D2620	Bent 206 Skidtube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	28932 JD 12-21

3.0	D2647	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	824842 BE 07-01-09

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650 } 06 06-12-20

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod M 101010 BE 07-01-09

4-Grind weld flush to cap on top surface only. BE 07-01-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A **Part Number:** D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
	5-Cut aft end 138.60" from front of tube ZT 07-01-09 6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312". DP 7-1-9 7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297". 8-Open using #6 Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail 10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650 11-Deburr and Blow out all chips form inside the tube DP 7-1-10	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 JD / BF 07-01-10	
6.0	D26547	206 I Beam (Web)
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2654-7 Web B 29333 Pm / Jb 7-1-11 (1)	
7.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. DP 7-1-11 4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: 7-1-11 Time: 11:50 Finish Date: 7-1-15 Time: 10:00 A/R Sikaflex-291 102 672 Sikaflex expiry date: 07-02-01 Pm / Jb 7-1-11 (1)	

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A **Part Number:** D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BE 07-01-15

9.0	D2649	Crossbolt Spacer

Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
23	D2649	Crossbolt spacer	B29329 BE 07-01-15

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod M 10101O BE 07-01-15

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube Pm 07-01-15 (1)

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr Pm 07-01-15 (1)

11.0	D2680041	Nut Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2680-041	Nut Plate	B24203 Pm 07-01-15 (1)

12.0	CCR264SS33	Cherry Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivets	m18548 Pm 07-01-15 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A
Part Number: D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	M7885343	Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 M7885/3-4-3 Rivets m19099 Pm 07-01-15 (1)

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Pm 07-01-15 (1)

Comment: HAND FINISHING RESOURCE #1
Install D2680-041 Nut Plate as per Dwg D2650

15.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION M 07/01/17 (1)

16.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP M 07/01/17 (1)

17.0	POWDER COATING	POWDER COATING

(1)
M 103141

Comment: POWDER COATING
Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3
Make sure Nut Plate Thread protected use paint screw
MK 07/02/05 ~~07-02-01~~ (1)

18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION a.a 07/02/06 (1)

19.0	D26483	Wearpad

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:
Qty Part Number Description Batch
6 D2648-3 Wearpad ~~[illegible]~~ B29226 YL 07/02/07 ~~07/02/08~~

20.0	D265615	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A **Part Number:** D206642441

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

1 D2656-15 Wearshoe 28694

21.0 D265623 Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2656-23 Wearshoe 24846

22.0 D265637 Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2656-37 Wearshoe 27473

23.0 D34291

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3429-1 Wearpad 29201

24.0 ALS41032130 Insert

Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)
Pick:
Qty Part Number Description Batch
60 ALS4-1032-130 Inserts 102475
or (see QSI 017)

25.0 AN960JD10L Washer

Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)
Pick:
Qty Part Number Description Batch
60 AN960JD10L Washer 102217

~~07/02/08~~

FOL/YC 07/02/06

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A

Part Number: D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
26.0	MS27039108	Screw

Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)
Pick:
Qty Part Number Description Batch
60 MS27039-1-08 Screw 101537

Seq. #:	Machine Or Operation:	Description :
27.0	D26511	Plug

Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)
Pick:
Qty Part Number Description Batch
22 D2651-1 Plugs B29330

Seq. #:	Machine Or Operation:	Description :
28.0	D26513	O-Ring

Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)
Pick:
Qty Part Number Description Batch
22 D2651-3 O-Rings B29778

Seq. #:	Machine Or Operation:	Description :
29.0	AN960JD416	Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 AN960JD416 Washer M11151

Seq. #:	Machine Or Operation:	Description :
30.0	MS27039406	Screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 MS27039-4-06 Screw B6874

FL / JL 07/02/08

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:05 PM
User: Kjm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A
Part Number: D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D2646	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2646 Aft Cap B28041

Seq. #:	Machine Or Operation:	Description :
32.0	AN960JD10L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN960JD10L Washer B102217

Seq. #:	Machine Or Operation:	Description :
33.0	MS27039108	Screw

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 MS27039-1-08 Screw m101537 FL/YL 07/02/06

Seq. #:	Machine Or Operation:	Description :
34.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
A/R Sikaflex-291 m102672
Sikaflex expiry date: 02/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
A/R Sikaflex-291 m102672
Sikaflex expiry date: 02/07

FL/YL 07/02/07 (1)

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4
Batch: m103004 FL/ 07/02/07 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ PAR #: ________ Fault Category: ________ NCR: Yes / No (circled: No) DQA: [signature] Date: 07/02/22

QA: N/C Closed: ______ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:02:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29325A
Part Number: D206642441

Job Number:

Seq. #:	Machine Or Operation:	Description :
35.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
36.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
37.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_______	
38.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS

DART

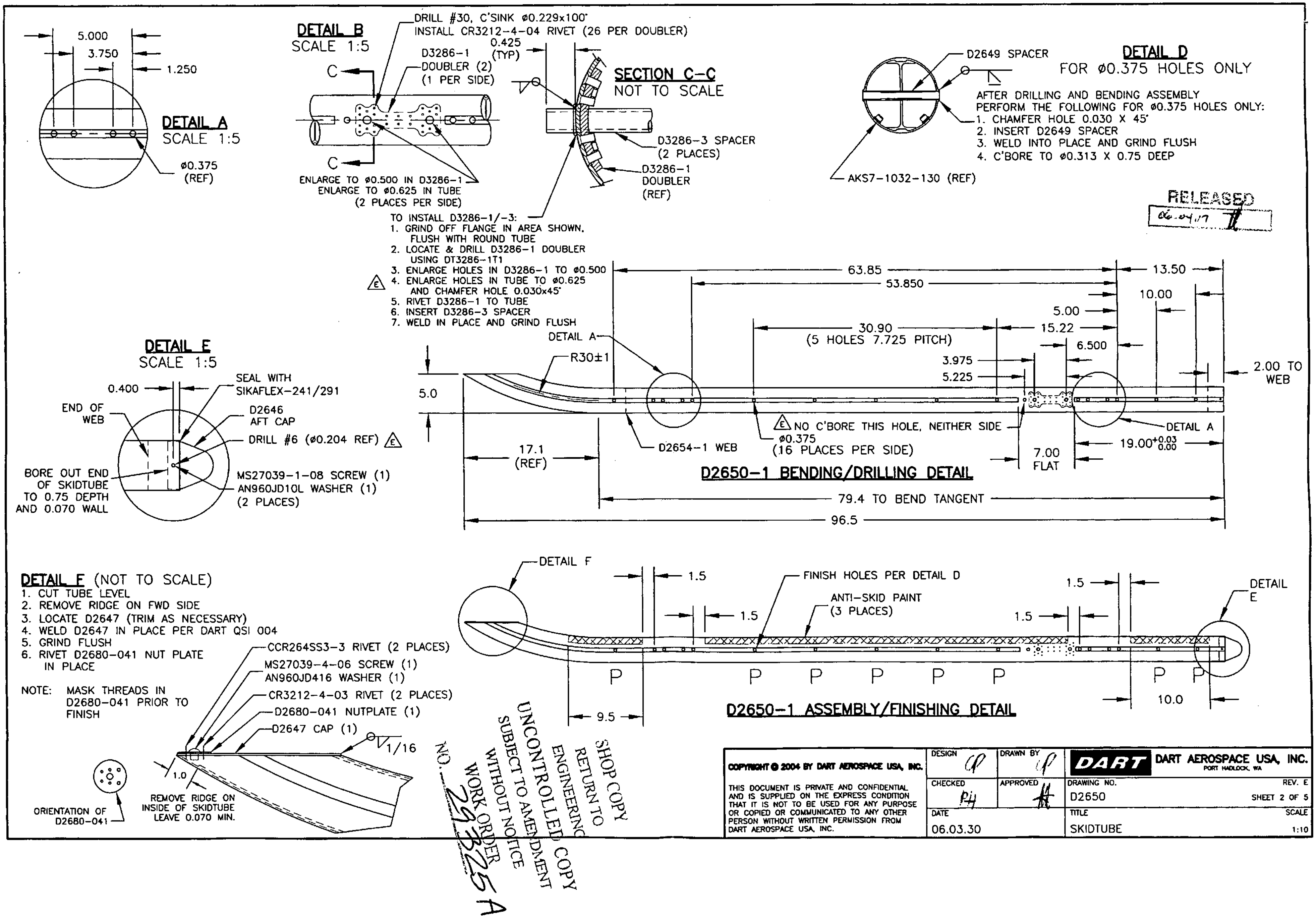
RELEASED 06.04.17

A	97.03.25	NEW ISSUE
B	97.06.26	AS MANUFACTURED CHANGES
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER

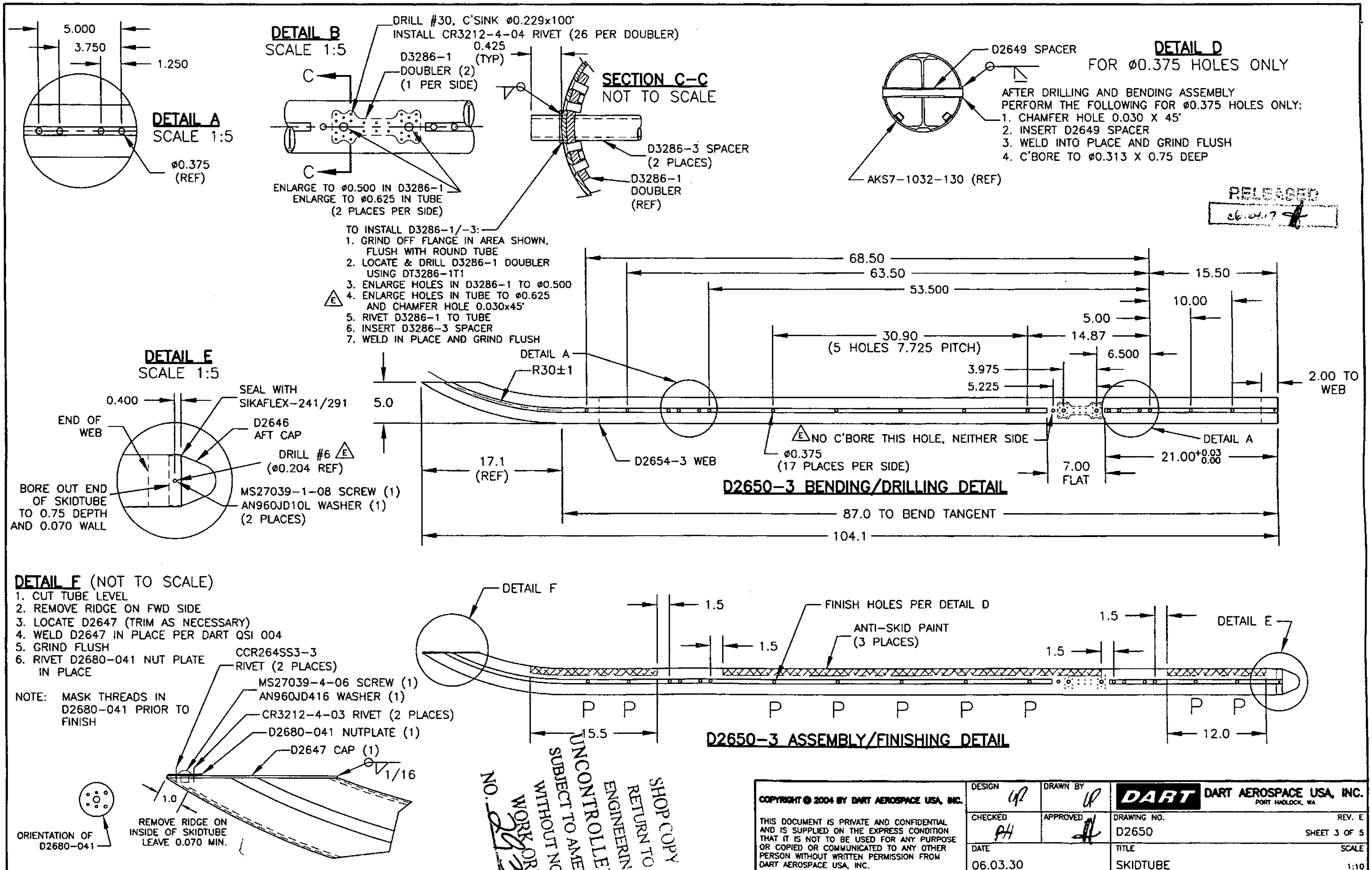
Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

1) WELD PER DART QSI 004
2) DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
   -BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
6) DRILL ∅0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON –1 TUBE, DT8056-3 ON –3 TUBE, DT8056-5 ON –5 TUBE, AND DT8056-7 ON –7 TUBE. INSTALL INSERTS AFTER FINISH.
7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2650 — REV. E — SHEET 2 OF 5
DATE 06.03.30		TITLE SKIDTUBE — SCALE 1:10


DETAIL A
SCALE 1:5
5.000
3.750
1.250
ø0.375
(REF)
DETAIL B
SCALE 1:5
DRILL #30, C'SINK ø0.229x100°
INSTALL CR3212-4-04 RIVET (26 PER DOUBLER)
0.425
(TYP)
D3286-1
DOUBLER (2)
(1 PER SIDE)
C
C
ENLARGE TO ø0.500 IN D3286-1
ENLARGE TO ø0.625 IN TUBE
(2 PLACES PER SIDE)
SECTION C-C
NOT TO SCALE
D3286-3 SPACER
(2 PLACES)
D3286-1
DOUBLER
(REF)
TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN. FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO ø0.500
4. ENLARGE HOLES IN TUBE TO ø0.625 AND CHAMFER HOLE 0.030x45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH
D2649 SPACER
DETAIL D
FOR ø0.375 HOLES ONLY
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO ø0.313 X 0.75 DEEP
AKS7-1032-130 (REF)
RELEASED
06.04.17
DETAIL E
SCALE 1:5
0.400
SEAL WITH SIKAFLEX-241/291
END OF WEB
D2646
AFT CAP
DRILL #6
(ø0.204 REF)
BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL
MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(2 PLACES)
68.50
63.50
53.500
15.50
10.00
5.00
30.90
(5 HOLES 7.725 PITCH)
14.87
6.500
3.975
5.225
2.00 TO WEB
DETAIL A
R30±1
5.0
NO C'BORE THIS HOLE, NEITHER SIDE
DETAIL A
D2654-3 WEB
ø0.375
(17 PLACES PER SIDE)
21.00 +0.03 / 0.00
17.1
(REF)
7.00
FLAT
D2650-3 BENDING/DRILLING DETAIL
87.0 TO BEND TANGENT
104.1
DETAIL F (NOT TO SCALE)
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH
CCR264SS3-3
RIVET (2 PLACES)
MS27039-4-06 SCREW (1)
AN960JD416 WASHER (1)
CR3212-4-03 RIVET (2 PLACES)
D2680-041 NUTPLATE (1)
D2647 CAP (1)
1/16
1.0
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
ORIENTATION OF D2680-041
DETAIL F
1.5
1.5
FINISH HOLES PER DETAIL D
ANTI-SKID PAINT
(3 PLACES)
1.5
1.5
DETAIL E
P P P P P P P P P
15.5
12.0
D2650-3 ASSEMBLY/FINISHING DETAIL
SHOP COPY
RETURN TO ENGINEERING
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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 2325A
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DRAWN BY
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DATE
06.03.30
DART
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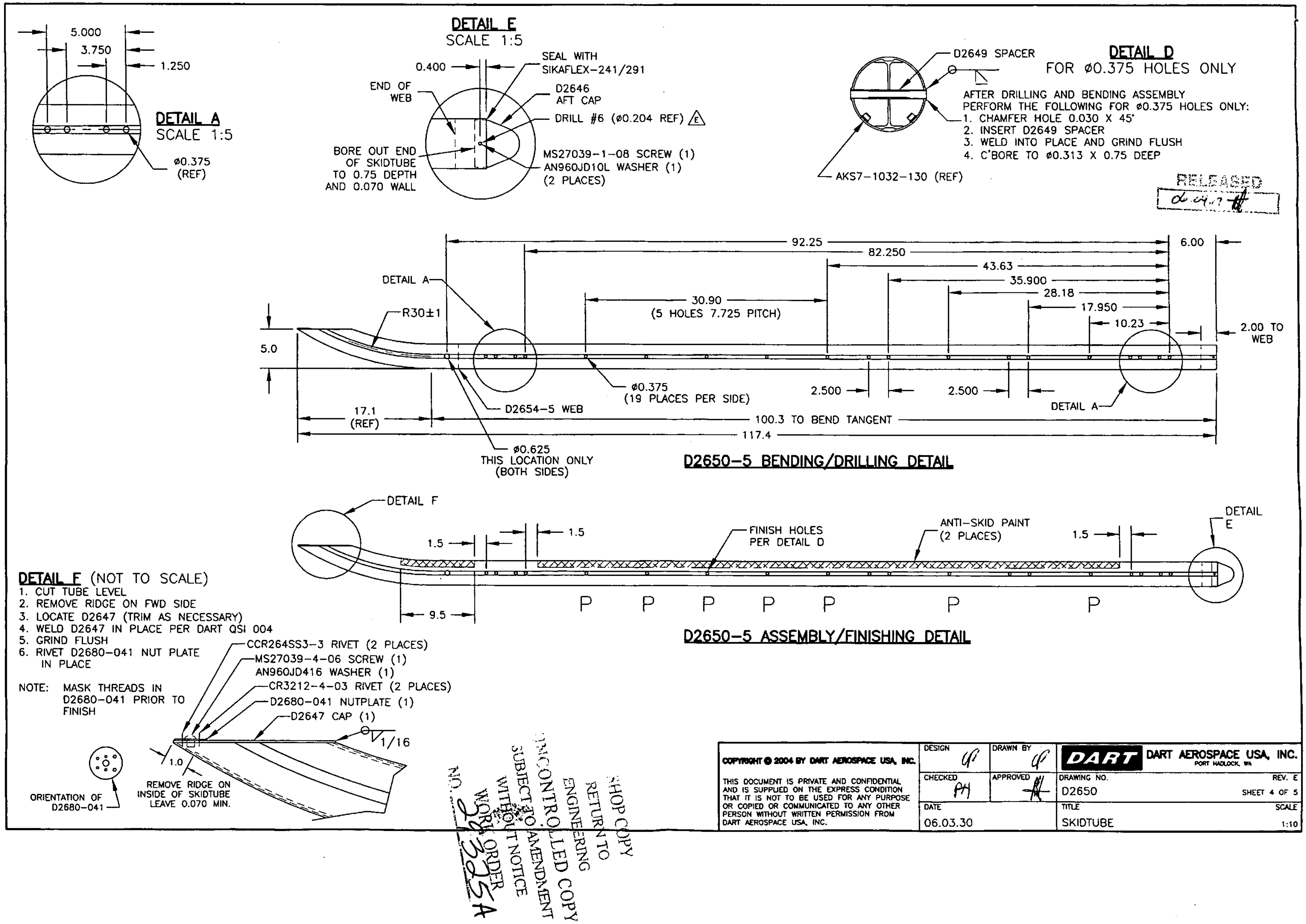
PORT HADLOCK, WA
DRAWING NO.
D2650
REV. E
SHEET 3 OF 5
TITLE
SKIDTUBE
SCALE
1:10



DETAIL A
SCALE 1:5
5.000
3.750
1.250
ø0.375 (REF)
DETAIL E
SCALE 1:5
0.400
END OF WEB
SEAL WITH SIKAFLEX-241/291
D2646 AFT CAP
DRILL #6 (ø0.204 REF) E
BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL
MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(2 PLACES)
D2649 SPACER
DETAIL D
FOR ø0.375 HOLES ONLY
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO ø0.313 X 0.75 DEEP
AKS7-1032-130 (REF)
RELEASED
92.25
82.250
43.63
35.900
28.18
17.950
10.23
6.00
2.00 TO WEB
DETAIL A
R30±1
30.90
(5 HOLES 7.725 PITCH)
5.0
ø0.375
(19 PLACES PER SIDE)
2.500
2.500
D2654-5 WEB
DETAIL A
17.1 (REF)
100.3 TO BEND TANGENT
117.4
ø0.625
THIS LOCATION ONLY
(BOTH SIDES)
D2650-5 BENDING/DRILLING DETAIL
DETAIL F
1.5
1.5
FINISH HOLES PER DETAIL D
ANTI-SKID PAINT (2 PLACES)
1.5
DETAIL E
9.5
P P P P P P P
D2650-5 ASSEMBLY/FINISHING DETAIL
DETAIL F (NOT TO SCALE)
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH
CCR264SS3-3 RIVET (2 PLACES)
MS27039-4-06 SCREW (1)
AN960JD416 WASHER (1)
CR3212-4-03 RIVET (2 PLACES)
D2680-041 NUTPLATE (1)
D2647 CAP (1)
1/16
1.0
ORIENTATION OF D2680-041
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
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DESIGN
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DATE
06.03.30
DART
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO.
D2650
REV. E
SHEET 4 OF 5
TITLE
SKIDTUBE
SCALE
1:10
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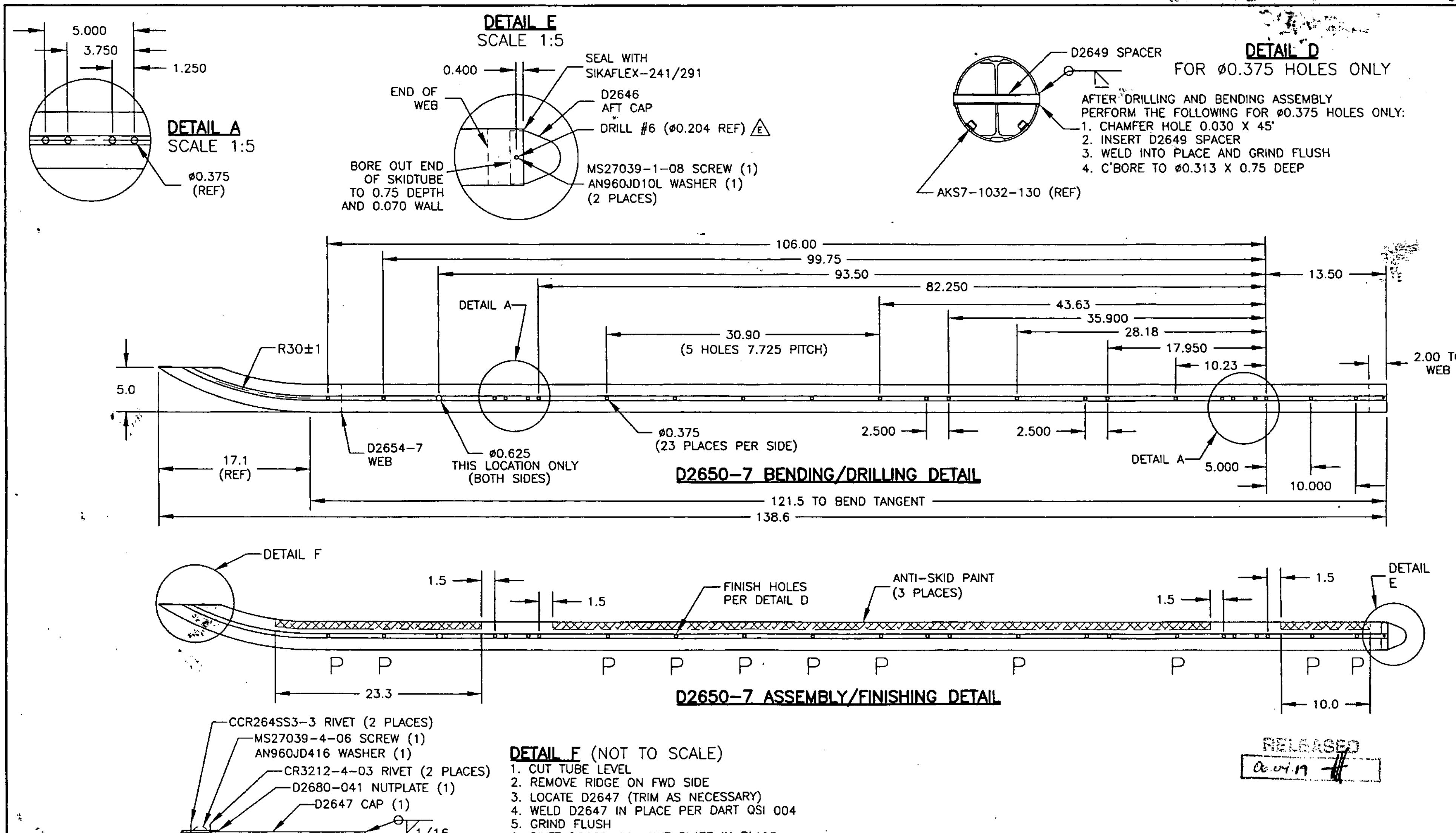
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER



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CHECKED	APPROVED	DRAWING NO. D2650	REV. E SHEET 5 OF 5
DATE 06.03.30		TITLE SKIDTUBE	SCALE 1:10

NO. 84

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D20B642341 / B28347A

TEST WELDS REQUIRED

BASE METAL Alum | WELDING PROCESS Tig
Penetration Complete [ ] Partial [✓] | Single Weld [✓] Double Weld [ ]
Current AC [✓] DC [ ] | Backing YES [ ] NO [✓]

Position | Vertical Down [ ] Up [ ]

Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ______ Skid/Tube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/01/09 Qualifier [signature]

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Monday, February 05, 2007 1:10 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: sikaflex-291

Jason,
Yes.
Bill

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 5, 2007 12:49 PM
To: 'Bill Beckett'
Subject: sikaflex-291

Bill,
We have 25 tubes of sikaflex-291,batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com
Q.C. COORDINATOR